

Processing Guidelines for KYDEX® T-IM

PROCESSING CONDITIONS

Barrel Temperatures

Rear:	360°F (182.2°C)
Middle:	365°F (185.0°C)
Front:	365°F (185.0°C)
Nozzle:	365°F (185.0°C)

Mold Temperature: 70 - 100°F (21.1 - 37.7°C)

Melt Temperature: 380°F (193.3°C) (Do not exceed 400°F (204.4°C))

Injection Speed: 0.5 - 1.0 in/sec (12.7 - 25.4 mm/sec)

Injection Pressure: 1,000 psi (6.9 MPa)

DRYING RECOMMENDATIONS

Drying is typically not required for KYDEX® T-IM.

If drying is required, 130°F (54.4°C) for 4 - 6 hours.

TOOLING GUIDELINES

Tooling Material: P20 steel*

*Tooling must be cleaned and neutralized after each run to prevent corrosion

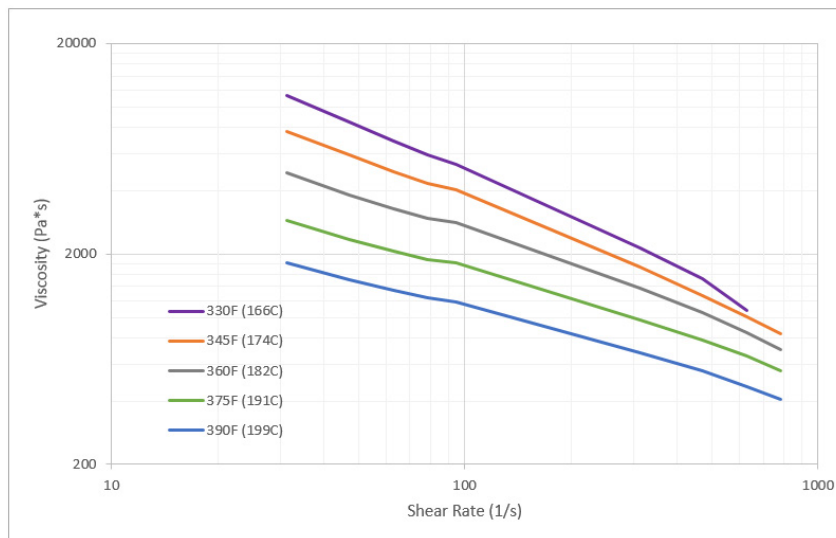
420-type stainless steel or chrome treated is an alternative for additional corrosion resistance

Draft Angle: 0.5° min. on textureless tooling**

**Draft angle for textured tooling will be dependent on the texture specifications

Mold Shrinkage: 0.25 - 0.45%

VISCOSITY CURVE



Customer Collaboration

6685 Low Street, Bloomsburg PA 17815 USA
 Phone: 800.325.3133, +1.570.389.5810
 Email: info@kydex.com

appLab™

Phone: 800.682.8758
 Email: applab@kydex.com

kydex.com

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